

Date: Friday, 01/05/2009 9:50:19 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 47645		
Estimate Number	: 13280		
P.O. Number	:	Part Number	: D3674041
This Issue	: 01/05/2009 S.O. No. :	Drawing Number	: D3674 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/05/2009 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 42514	Material	:
Written By	: <u>JP 09-05-01</u>	Due Date	: 08/05/2009 Qty: 6 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 08-04-25 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B1250X02000	17-4 SS Bar 1.250 x 2.00
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Comment: Qty.: 0.5775 f(s)/Unit Total: 3.4650 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.250x02.000)
 Identify for D3674-1
 Batch: M1109851

mk 09/05/05

⑥

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (1.250" x 2.000") 5.400" long

mk 09/05/05

⑥

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-1

2-Deburr

3-Scribe batch number

SP 09/03/08

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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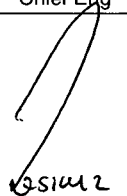
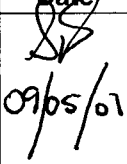
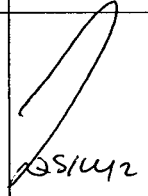
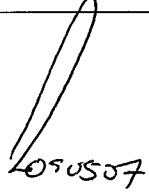


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SP 09/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3674-041 PAR #: N/A Fault Category: Prod / Machined NCR: (Yes) No DQA: Si Date: 09/05/12
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: Si Date: 09/05/12

NCR: 47645		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/5/5	3.0	1 part (1st one) has a 3/16 rad. at the upper section. Should be 0.250 rad. Incorrect tool was placed into the machine. From the other shift. RC: lack of Attention		Scrap & replace. Qty 1 M109857 Follow is clear.	 09/05/07	J.L. 09/05/07		

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 47645

Part Number: D3674041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/05/08

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt

646739

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

346031

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3674-041 as per Dwg D3674

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/11 (X6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 236B

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12

Job Completion



MF 09-05-12

DART AEROSPACE LTD		Work Order: 47645
Description: Bracket		Part Number: D3674-1
Inspection Dwg: D3674	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

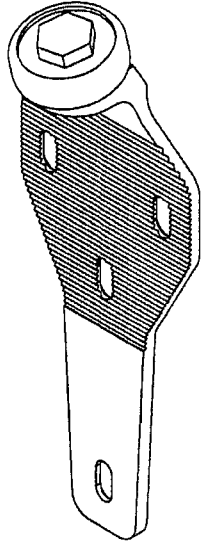
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	+/-0.010	1.966	✓			
0.750	+/-0.010	.753	✓			
0.605	+/-0.010	.606	✓			
3.380	+/-0.010	3.378	✓			
2.430	+/-0.010	2.427	✓			
0.380	+/-0.010	.377	✓			
0.73	+/-0.030	.730	✓			
0.95	+/-0.030	.952	✓			
2.140	+/-0.010	2.145	✓			
2.030	+/-0.010	2.033	✓			
4.718	+/-0.010	4.718	✓			
4.590	+/-0.010	4.590				
0.863	+/-0.010	.868	✓			
0.130	+/-0.010	.129	✓			
4.600	+/-0.010	4.610	✓			
4.880	+/-0.010	4.883	✓			
5.139	+/-0.010	5.132	✓			
R0.25	+/-0.030	.250	✓			
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.305	✓			
30°	+/-0.5°	30°	✓			
Ø0.573	+/-0.010	.575	✓			
0.720	+/-0.010	.720	✓			
0.345	+/-0.010	.345	✓			
Ø0.392	+0.002/-0.000	.392	✓			
2.173	+/-0.010	2.180	✓			
3.135	+/-0.010	3.135	✓			
3.963	+/-0.010	3.963	✓			
4.365	+/-0.010	4.365	✓			
0.664	+/-0.010	.664	✓			
100°	+/-0.5°	100°	✓			
0.076	+/-0.010	.077	✓			
0.200	+/-0.010	.204	✓			
0.200	+/-0.010	.204	✓			
R0.10	+/-0.030	.100	✓			
0.032	+0.000/-0.010	.025				

8 7 6 5 4 3 2 1

QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET

w/o 47645



D3674-041 BRACKET ASSEMBLY

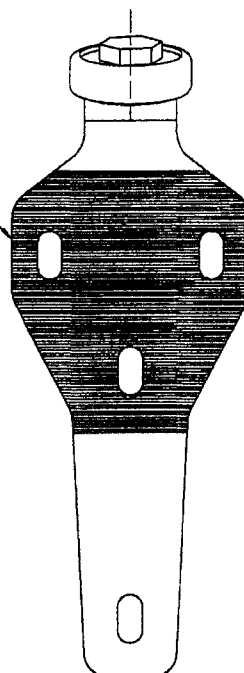
RELEASED
08-06-26

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: N/A
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT 0.23 lbs
 - 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ALB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SWB	DRAWING NO.	REV. A
MFG. APPR.	SWB	D3674	SHEET 1 OF 4
APPROVED	SWB	TITLE	SCALE
DE APPR.	SWB	ROLLER BRACKET ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D3674-1 BRACKET



D3121-21 BOLT

D3121-241 BEARING ASSEMBLY

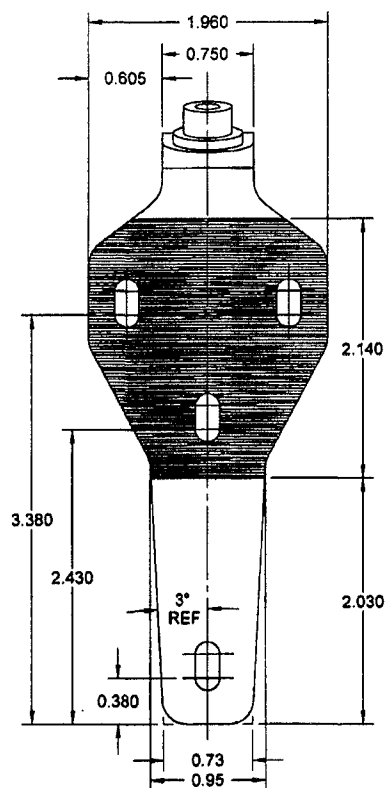


D3674-041 BRACKET ASSEMBLY

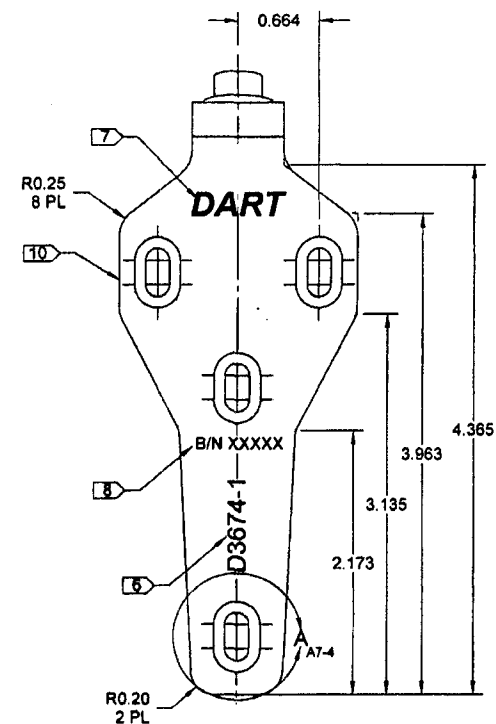
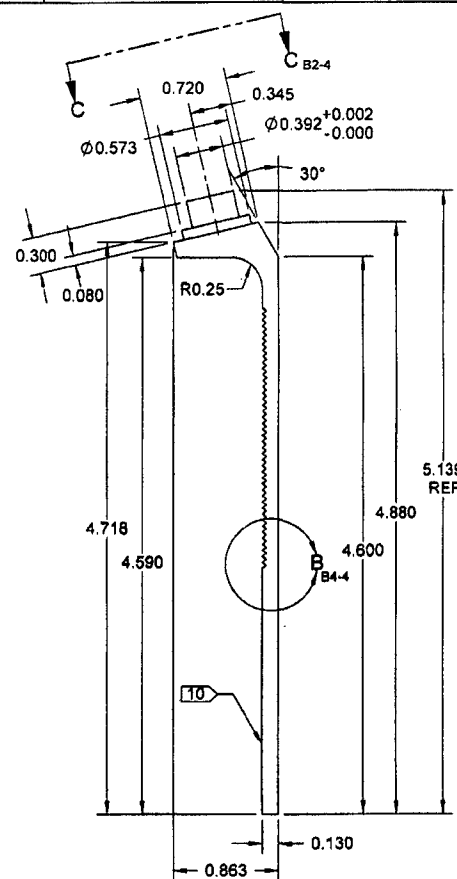
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08.03.26

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DRAWN	MS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. A
MFG. APPR.	MS	D3674	SHEET 2 OF 4
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DE APPR.	MS	ROLLER BRACKET ASSEMBLY	NTS
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D3674-1 BRACKET



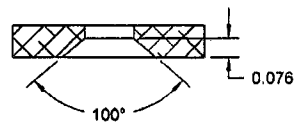
NOTES:

- 1) MATERIAL: 17-4 PH, STAINLESS STEEL BAR
PER AMS 5804/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.

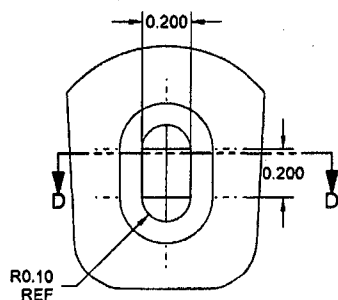
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28-06-26/16

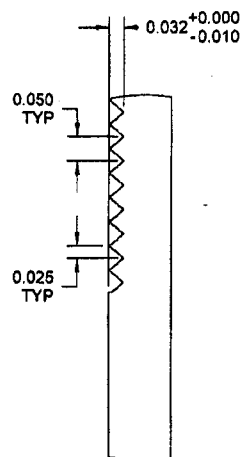
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	DRAWING NO. D3674	REV. A
MFG. APPR.	[Signature]	TITLE	SHEET 3 OF 4
APPROVED	[Signature]	ROLLER BRACKET ASSEMBLY	SCALE
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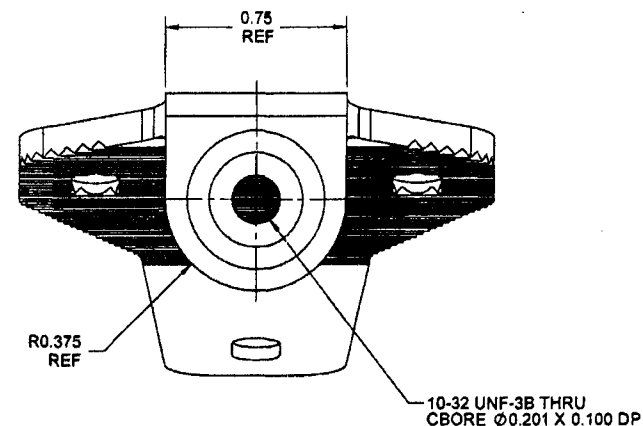
SECTION D-D



DETAIL A B2-3
SCALE 2X
(SLOT DETAIL 4PL)



DETAIL B C4-3
SCALE 4X
(RIDGE DETAIL)



VIEW C-C B3-3
SCALE 2X

RELEASED
08 06 26 11/11

47645

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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